Work Order ID 67989

Tuesday, April 05, 2011 10:41:37 AM

Item ID: D4380-5
Revision ID: PRELIM
Item Name: Vent, Aft

Start Date: 4/5/2011 **Start Qty:** 2.00
Required Date: 4/5/2011 **Req'd Qty:** 2.00
Reference:

Accept

Setup Start

Stop

PRELIMINARY ISSUE

Cust Item ID:
Customer:

Run Start

Stop

Approvals: **Process Plan:** MF **Date:** 11-04-05 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4380	Revision Nbr: PA6 ~~PA7~~ ~~DL~~ 11/04/05 AH								
100		0.00							
HandThermo		0.00				2			BB 11/04/05
Hand Finishing Thermoforming	**Memo** 1-Cut Sheet to required Blank size								
105		0.00							
HandThermo	Dry Material	0.00				2			BB 11/04/05
Hand Finishing Thermoforming	**Memo** Dry Sheet as per QSI022 Kydex Temp: 180 Time IN: 6:00 PM 11/04/04 Time OUT: 7:00 AM 11/04/05								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67989

Tuesday, April 05, 2011 10:41:38 AM

Item ID: D4380-5
Revision ID: PRELIM
Item Name: Vent, Aft

Start Date: 4/5/2011 **Start Qty:** 2.00
Required Date: 4/5/2011 **Req'd Qty:** 2.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00				2			BB 11/04/05
Thermoform	**Memo**	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA112 using tool DT9737 Dwg Rev: PA7 Folio Rev: A								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				2			BB 11/04/05
QC	**Memo**	0.00							
Quality Control	Visuallly inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00				2			DL 11/04/05
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67989

Tuesday, April 05, 2011 10:41:38 AM

Item ID: D4380-5
Revision ID: PRELIM
Item Name: Vent, Aft

Accept **Setup Start** **Stop**

Start Date: 4/5/2011 **Start Qty:** 2.00
Required Date: 4/5/2011 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
HandThermo	**Memo**	0.00				2.			DL 11/04/05
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				2			BB 11/04/05
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00 – inspected to Part Dwg only 11/04/06 KD							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67989

Tuesday, April 05, 2011 10:41:38 AM

Item ID: D4380-5
Revision ID: PRELIM
Item Name: Vent, Aft

Start Date: 4/5/2011 **Start Qty:** 2.00
Required Date: 4/5/2011 **Req'd Qty:** 2.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: RACK	0.00							
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

4/4/16 (2)

11/5/16 AJ

RD2370

MF

POSITIVE RECALL
EFFECTIVE 11-04-05 AUTH 4-11-04-06
RELEASED MF DATE 11/05/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:41:33 AM

Work Order ID: 67989

Parent Item: D4380-5

Parent Item Name: Vent, Aft

Start Date: 4/5/2011 **Required Date:** 4/5/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: Rev. A New Issue 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	787.2912	3.46875	6.9375			

6185 KYDEX .080"

Location	Loc Qty	Loc Code
therm	787.2912	
116576	787.2912	

6.9375 sq ft

DL 11/04/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	67989
Description: VENT AFT	Part Number:	D4380-5 1
Inspection Dwg: 4380-5 Rev: PA7		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than ____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 11/04/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.5	± .100	11.4	✓		TAPE THOS	
8.0	± .100	8	✓		TH OS	
~~9.5~~ 9.5	± .100	9.5	✓		TH-OS	
6.0	± .100	6.0	✓		TH-OS	

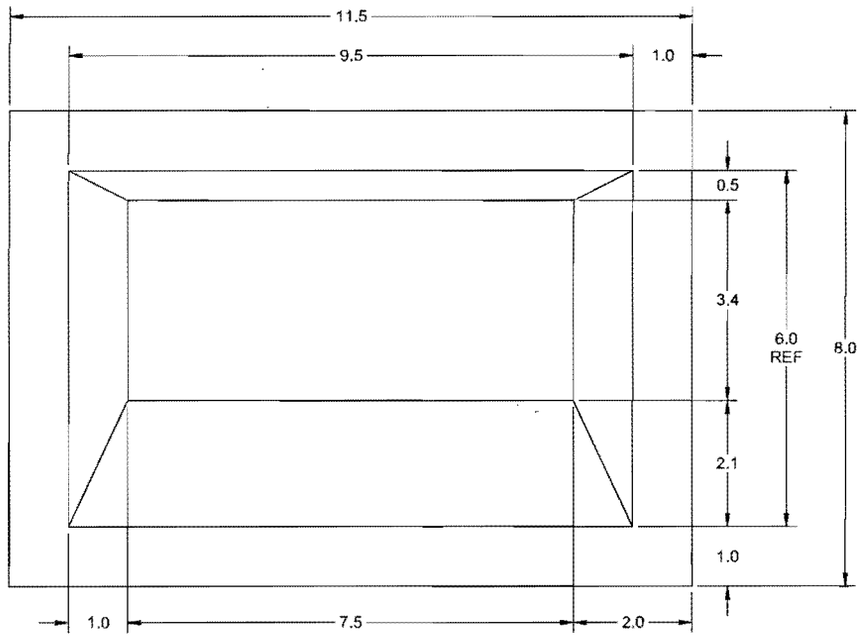
Measured by: BB Date: 11/04/05

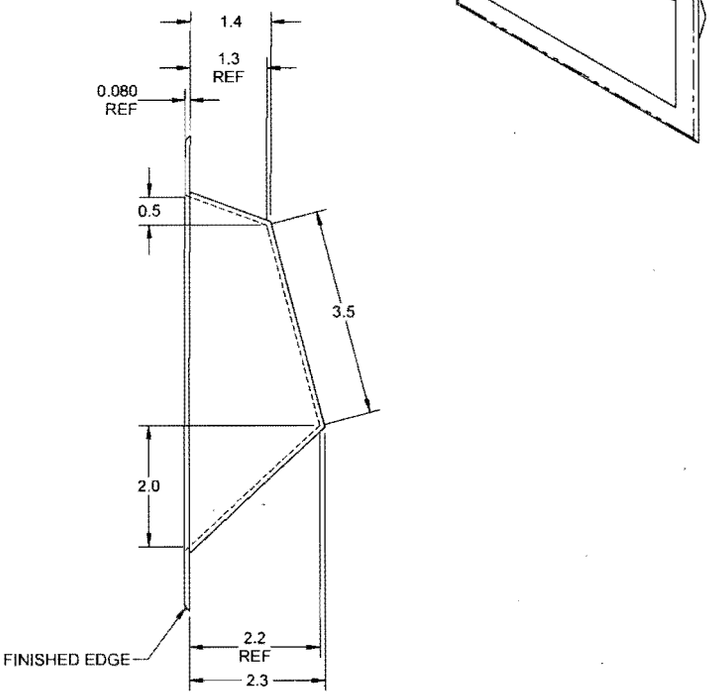
Audited by: S.K. to PA7 Dwg only Date: 11/04/06

Preliminary Approval: Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14





NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.47 lbs
8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
9) TOOLING: THERMOFORM -5 PART PER MOULD DT9737.
TRIM PER MOULD LEAVING FINISHED EDGE.

D4380-5 VENT, AFT

PRELIMINARY ISSUE
BC 11.04.05

DESIGN	BC	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	BC	
CHECKED		DRAWING NO. D4380 REV. PA7
MFG. APPR.		SHEET 3 OF 19
APPROVED		TITLE CEILING POCKETS SCALE NTS
DE APPR.		
DATE	11.04.05	

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Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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Dart Aerospace Ltd

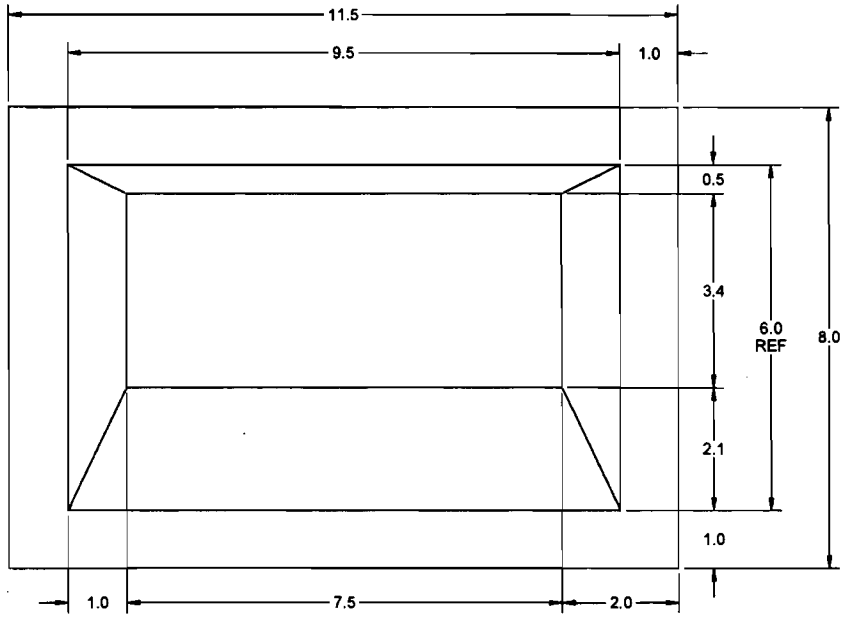
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

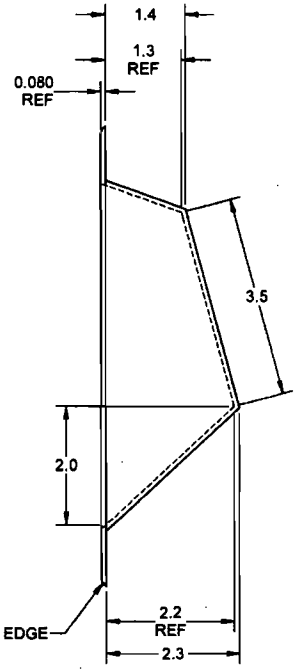
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

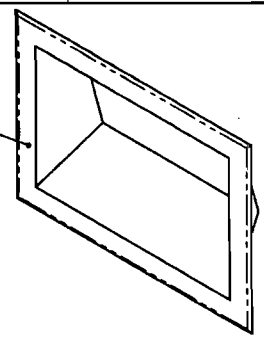
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries







67989

RELEASED
2011-05-19

D4380-5 VENT, AFT

NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 0.47 lbs
8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
9) TOOLING: THERMOFORM PER MOULD DT9737 AND DART QSI 022
10) TRIM PER MOULD LEAVING FINISHED EDGE
11) MAXIMUM INSIDE RADIUS = 0.188

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED		DRAWING NO. D4380 REV. A
MFG. APPR.		SHEET 3 OF 19
APPROVED		TITLE CEILING POCKETS SCALE NTS
DE APPR.		
DATE	11.04.21	

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